

Date: Wednesday, 10/09/2008 1:52:44 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PIN			
Job Number	: 41930						
Estimate Number	: 12672						
P.O. Number	:		Part Number	: D31471			
This Issue	: 10/09/2008	S.O. No. :	Drawing Number	: D3147 REV C			
Prsht Rev.	: NC		Project Number	: N/A			
First Issue	: / /		Drawing Revision	: C			
Previous Run	: 41616		Material	:			
Written By	:		Due Date	: 10/05/2008			
Checked & Approved By	: <u>JUL 08 9.10</u>		Qty:	20 Um: Each			
Comment	: Est Rev A New Issue 07-01-26 JLM						
	: Est Rev:B Now on Cnc 07-05-02 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M303R0187	303 Round Bar 0.187"	
		Comment: Qty.: 0.2363 f(s)/Unit Total : 4.7250 f(s) 303 Round Bar 0.187"	
		Batch: <u>M105341</u>	J.F. 08/10/14 (21)
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: 1-TURN AS PER FOLIO FA691 & DWG D3147 , FOLIO REV: <u></u> DWG REV: <u>C</u>	
		2-DEBURR AS REQUIRED	J.F. 08/10/14 (21)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 08/10/14 (21)
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1- Mill as per Folio FA691 Rev: _____ & Dwg D3147 Rev: _____	
		2-Deburr per dwg D3443	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		N/A
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
6.0	QC8	SECOND CHECK
		8/10/11 (21)
	Comment: SECOND CHECK	
7.0	PACKAGING 1	PACKAGING RESOURCE #1
		21A
	Comment: PACKAGING RESOURCE #1	
	Identify and Stock	
	Location: 69	
		8/10/15
		SP
8.0	QC21	FINAL INSPECTION/W/O RELEASE
		08/10/15 (21)
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion



MF 08-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41930
Description: Pin	Part Number:	D3147-1
Inspection Dwg: D3147	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

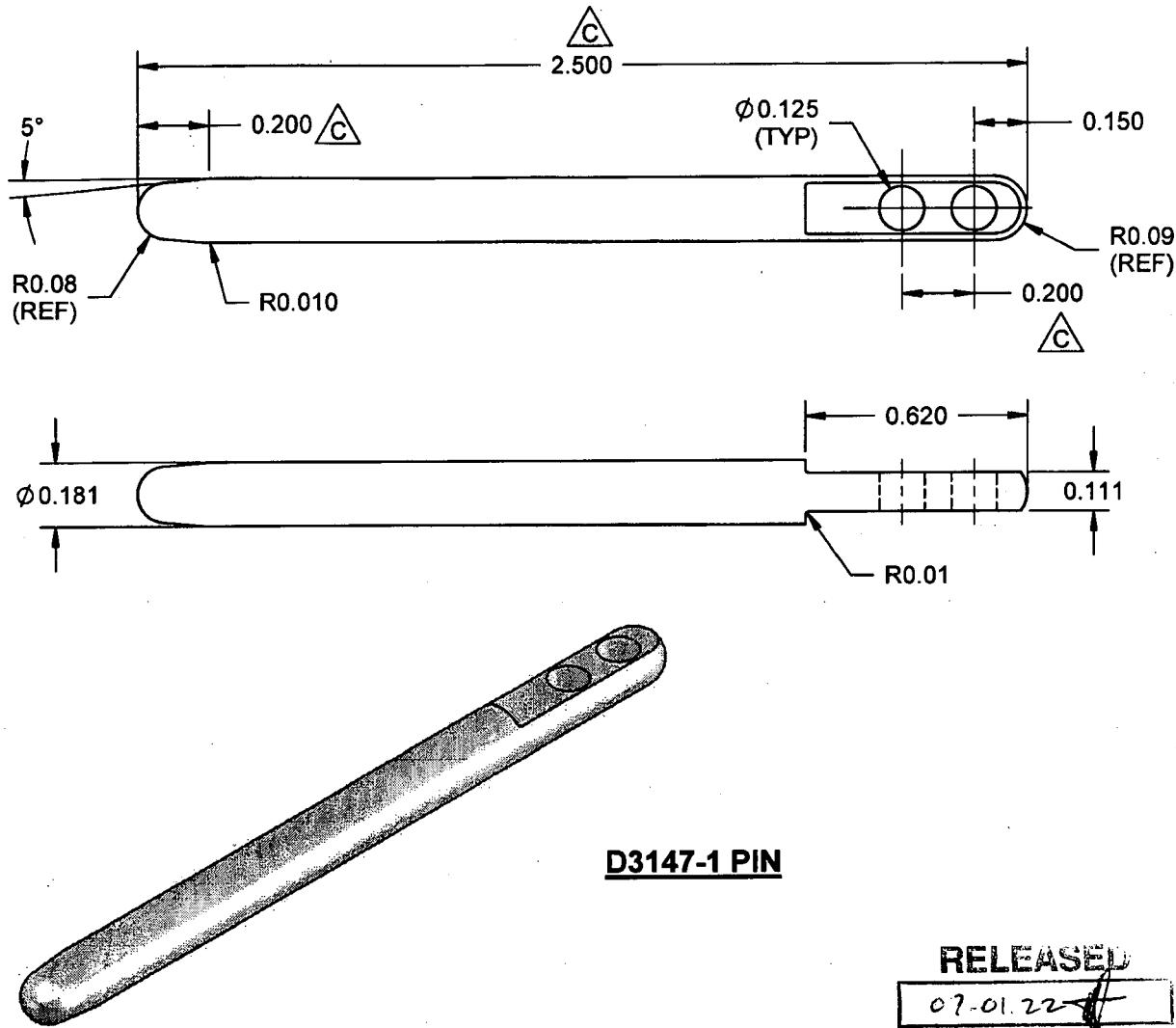
X First Article Prototype

Measured by:	J.F.	Audited by:	86	Prototype Approval:	N/A
Date:	08/10/14	Date:	08/10/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	DA

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. C D3147 SHEET 1 OF 1
DATE	06.12.04	TITLE PIN SCALE 2:1
REV	DATE	DESCRIPTION
A	02.04.23	NEW ISSUE
B	04.10.18	ADD PART MARKING AND NORMALIZED
C	06.12.04	ADD SECOND ϕ 0.125 HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING

**D3147-1 PIN****RELEASED**

07-01-22

NOTES:

1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX

7) REPLACES PREMIER P/N B30-23000-119

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 4930

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